

Work Order ID 69392

Tuesday, May 10, 2011 2:36:00 PM



Page 1

Item ID: D3167-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3167

Rev A1

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D3167-1_BLANK

11-5-11

4

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit
1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA285 and Dwg D3167
3-Deburr

M.A 11/05/26

4

φ

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

M.A 11/05/26

4

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69392

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Page 2

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Item Name: Bearpaw

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00

inf 11/05/30

QC

Memo

0.00

Quality Control

9 *0*

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

POP69392

0.00

Packaging

11/05/30 *(4)*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/31 *(4)**11-05-30*
(4)

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Picklist Print

Tuesday, May 10, 2011 2:36:38 PM

Page 1

Work Order ID: 69392



Parent Item: D3167-1



Parent Item Name: Bearpaw

Start Date: 5/10/2011

Required Date: 5/13/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	163.0000	3.6	14.4			



UHMW 1" Black



B11-5-11

Location

Loc Qty

Loc Code

MAT018

163

116554

2

117321

161

117321

(4)

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DART AEROSPACE LTD		Work Order: 69392
Description: Bearpaw		Part Number: D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.050x45°	✓		Vern	GA-01
B	5.80	+/-0.030	5.800	✓		"	"
C	0.25 x 45°	+/-0.030	0.247x45°	✓		"	"
D	R0.25	+/-0.030	R0.250	✓		R-6	ref.
E	0.200	+/-0.030	0.204	✓		D-6	GA-08
F	0.250	+/-0.010	0.252	✓		Vern	GA-01
G	0.625	+/-0.030	0.630	✓		"	"
H	0.375	+/-0.010	0.375	✓		"	"
I	0.950	+0.030/-0.010	0.956	✓		"	"
J	3.21	+/-0.030	3.215	✓		"	"
K	19.00	+/-0.030	19.000	✓		TAPE	GA-12
L	Ø0.260	+0.005/-0.000	Ø0.259	✓		Vern	GA-01
M	Ø0.93	+/-0.030	Ø0.923	✓		"	"
N	0.30	+0.030/-0.000	0.307	✓		D-6	GA-08
O	0.375	+/-0.030	0.380	✓		Vern	GA-01
P	7.23	+/-0.030	7.235	✓		Vern	CNC-02
Q	4.54	+/-0.010	4.548	✓		Vern	GA-01
R	2.00	+/-0.030	2.002	✓		"	"
S	12.000	+/-0.010	12.000	✓		Vern	CNC-02
T	6.000	+/-0.010	6.000	✓		Vern	GA-01
U	23.75	+/-0.030	23.750	✓		TAPE	GA-12

Measured by: B.A	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/05/26	Date: 11/05/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF [Signature]	[Signature]

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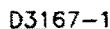
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NOTE: Date & initial all entries

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06-10-25-11



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 69392

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

P 1105-10

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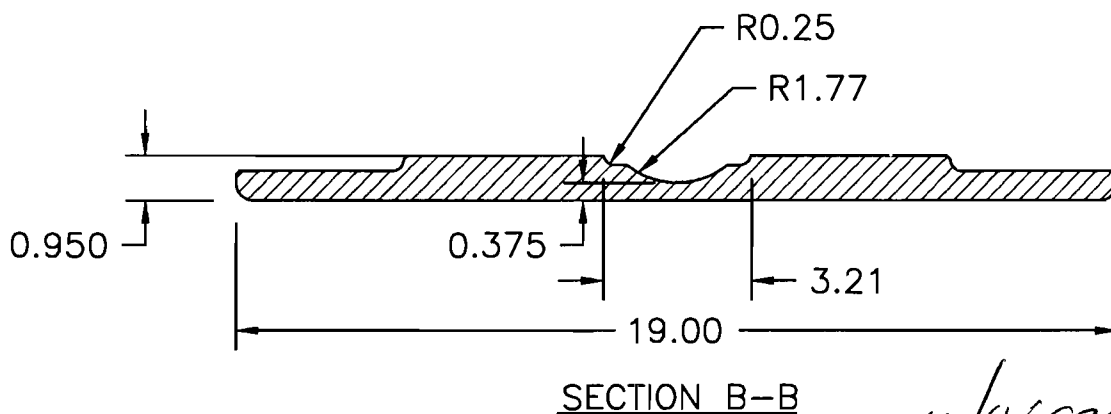
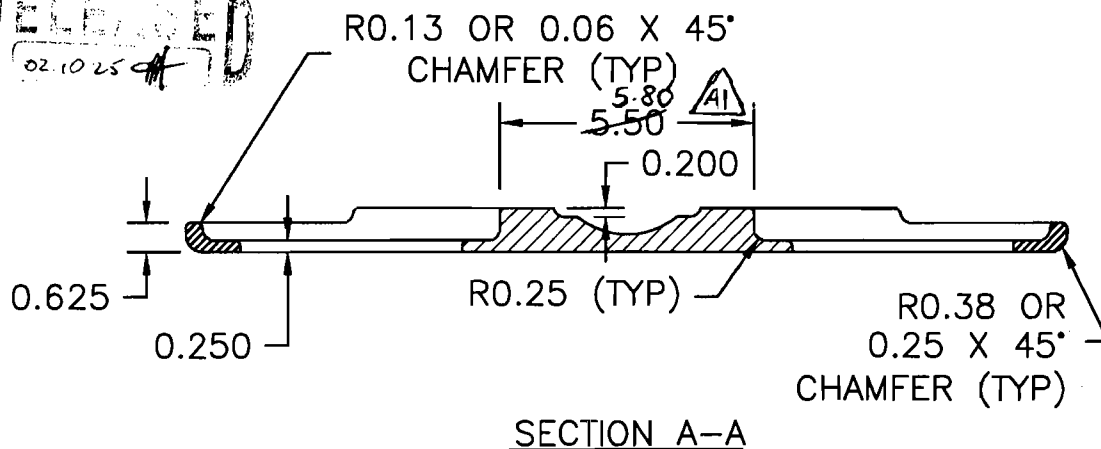
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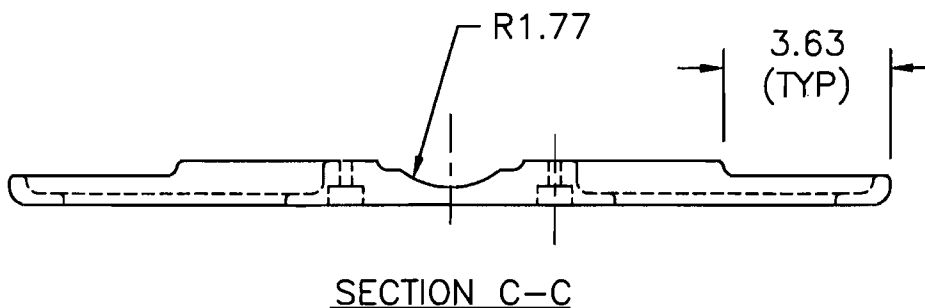


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

RELEASED
02.10.25



u1069392



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